

Date: Monday, 07/04/2008 11:47:47 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR SUPPORT KIT
Job Number	: 38438		
Estimate Number	: 12112		
P.O. Number	:	Part Number	: D412698015
This Issue	: 07/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN D412-698 REVD
First Issue	: / /	Project Number	: N/A
Previous Run	: 36743	Drawing Revision	: D
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 18/04/2008
Checked & Approved By	: <u>JVO</u> <u>08.4.06</u>	Qty:	10 Um: Each
Comment	: Est Rev:C Removed Manufacturing 06-01-25 JLM Est Rev:D change to rev D ECN 1104 08-01-28 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

08/4/15 JLD

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D32001	Door Post Block
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3200-1 Door Post Block

B36753

4.0	D32003	Door Wedge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3200-3 Door Wedge

36754 14x B38526 6x

5.0	D32011	Doubler
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

B36755

Date: Monday, 07/04/2008 11:47:47 AM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SUPPORT KIT

Job Number: 38438

Part Number: D412698015

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D3201-1 Doubler *W*

6.0

D32013

Doubler



↓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-3 Angle *B36756*

7.0

D32014

Doubler



↓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-4 Angle *B36757*

8.0

AN960JD10L

Washer



↓ Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD10L Washer *M104885*

9.0

MS21042L3

Nut



↓ Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L3 Nut (or -3) *M106883*

10.0

MS24693S277

Screw



↓ Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS24693-S277 Screw *M106883 37K*

M107737

PC 8/4/15 (10)

Date: Monday, 07/04/2008 11:47:48 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SUPPORT KIT

Job Number: 38438

Part Number: D412698015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

0804-16 (10) Kits in box w/ paper work.

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-015

Location: *22*

PPP Rev: *A*

8/4/16 SP

(10)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/16

Job Completion



MF 08-04-16

6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
					7		D3121-21	BOLT
					5		D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
					1		D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
					2		D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9			9			D3199-1	BRACKET
1	1			1			D3202-1	COVER
		4					D3203-1	HANDLE
		1					D3220-041	DOUBLER
		1					D3220-042	DOUBLER
		2					D3220-3	DOUBLER
			2				D3200-1	DOOR POST BLOCK
			2				D3200-3	DOOR WEDGE
			2				D3201-1	DOUBLER
			1				D3201-3	ANGLE
			1				D3201-4	ANGLE
						3	D3238-1	SHIM
						1	D3238-3	SHIM
						2	D3238-5	SHIM
						6	D3238-11	SHIM
						2	D3238-13	SHIM
						4	D3238-15	SHIM
			12				AN960JD10L	WASHER
		8					AN960JD416L	WASHER
			12				MS21042L3	NUT (OR MS21042-3)
		8					MS21042L4	NUT (OR MS21042-4)
		16					MS24694-S98	SCREW
					1		MS24694-S101	SCREW
			12				MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

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WORK ORDER

NO. 38438

Revision: D

Date: 07.07.03

(CONTINUED FROM PAGE 14)

Qty -023	Part Number	Description
X	D412-698-023	AUTOMATIC DOOR OPENER KIT
1	D3552-11	GAS SPRING
1	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
1	D3594-044	FLOOR DOUBLER ASSMEBLY, RH
2	D3622-1	BALL STUD
2	AN960JD516L	WASHER

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Revision: **D**
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